

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025844**Date Inspected:** 06-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Components				

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**Trial Assembly Area**

Caltrans and ABF have agreed to conduct visual and magnetic particle (MT) inspections of welds as part of a special joint inspection program. In response to ZPMC NDT Inspection Notification Sheets (NWIT) #09660 for MT inspection this QA Inspector proceeded to the Trial Assembly Area to perform random visual testing (VT) and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel per NWIT #09660. This QA Inspector was informed by ZPMC QC Xie Gen Lin (QC1) that ZPMC personnel were cleaning and grinding the welds to be inspected. QC1 instructed this QA Inspector to wait until the cleaning and grinding was completed. QC1 later informed this QA Inspector that NWIT #09660 was cancelled by ZPMC.

**Blast Shop 4**

This QA Inspector and QA Inspectors Paul Dawson and Kelly Leavitt responding to phone notification from ABF Inspectors performed a pre-final sandblast inspection of Segment 13AW, architectural area, between panel point 117.3 and panel point 120. This QA Inspector observed several surface irregularities requiring grinding. These areas were marked for grinding. This QA Inspector observed several surface irregularities appearing to be arc strikes requiring grinding and magnetic particle testing (MT). These areas were marked for grinding and MT. This QA Inspector also observed welds missing at panel point 120 at and near the deck panel. The missing welds were documented on a weld map not showing the specific weld numbers. The location of the welds were communicated to day shift QA Inspector personnel for documentation and entry into a data base.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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